



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ASAP / AOG

D5557-1
Job Sheet 187921



Part No: D5557-1

Job Qty: 4 ea

Part Name: Cutter Blade



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/20/18

Job Tracking No:

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: TBD Dwg D5557 Rev.A7 IPP Rev.A New issue 18/01/29 JFS Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	12/21/18	12/21/18	0.00	0.00	Start Up Machining-4		mmmc 18/61/05
110	CNC Vertical Machining	4 pcs	12/21/18	12/21/18	0.00	2.00	HAAS1-1		mmmc 18/61/05
120	QC	4 pcs	12/21/18	12/21/18	0.00	0.00	QC2 Machining-4		
130	QC	4 pcs	12/21/18	12/21/18	0.00	0.00	QC8 Machining-4		B.p 19-01-04
140	Outsource	4 pcs	12/21/18	12/21/18			MEI001-VC	10	GF 19-1-6
150	Packaging	4 pcs	12/21/18	12/21/18	0.00	0.00	Packaging2		8 JAN 14 2019
155	QC	4 pcs	12/21/18	12/21/18	0.00	0.00	QC6		38
160	SprayPaint	4 pcs	12/21/18	12/21/18	0.00	0.02	Spray Paint		18 19-1-14
170	QC	4 pcs	12/21/18	12/21/18	0.00	0.00	QC14		DAS
180	Packaging	4 pcs	12/21/18	12/21/18	0.00	0.00	Packaging3-2		JAN 15 2019 68
190	QC21-SA	4 Ea	12/21/18	12/21/18	0.00	0.00	QC21		21 9-89

Part Op 90 - Cut Blank at 4.625"

Descriptions: 110 - 1-Machine per folio FB765 DWG REV: FOLIO REV: 2- Deburr and break all sharp edges EXCEPT OTHERWISE NOTED. SEE NOTE 8 ***KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL BURRS ON CUTTING EDGE***

140 - PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED

160 - PRIME AS PER DWG AND QSI005, SEE NOTE #2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX*** PRIMER BATCH: 138981

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	1.5440 ft (.386 ea)	90-Start up Operation	5132658

Job Allocations



Container No: S141674



Part: D5557-1

Job No: 187921

Serial No/Batch: S141674

Revision: PA7

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.darteerospace.com

Required	Inventory	Allocated
2	55	0

Allocations

Limits	Type	Special Comments
1.030	Product	
1.000		

Plex 12/20/18 2:03 PM Dart.lajeunesse.marie

Date: 01/03/19

pls ship
to DOS
ASAP!

MAT
used
1.660

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐		
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)
Description Work Order Deviation				Disposition		Completed By
						Lead hand / Supervisor
						QC / QA Coordinator
FAULT CATEGORY						
rced		☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong		
		☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance		
		☐ BOM/Route	☐ Grain Direction	☐ Drawing		
		☐ Broken/Damage/Defect	☐ Weld	☐ Finish		
Ripple/Wave/Twist		☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
atter		☐ Drill Holes	☐ Out of Sequence	☐ Misread		
ed		☐ Fit/Function	☐ Off-set/Set-up			

2	Cutter Blade	0.2500inches $\pm$ 0.0020	0.2520 0.2480	
3	Cutter Blade	0.5630inches $\pm$ 0.0100	0.5730 0.5530	
4	Cutter Blade	1.2000inches $\pm$ 0.0100	1.2100 1.1900	
5	Cutter Blade	0.1700inches + 0.0050 - 0.0010	0.1750 0.1690	
6	Cutter Blade	0.3400inches + 0.0000 - 0.0040	0.3400 0.3360	
7	Cutter Blade	0.2510inches $\pm$ 0.0100	0.2610 0.2410	
8	Cutter Blade	0.3380inches $\pm$ 0.0100	0.3480 0.3280	
9	Cutter Blade	4.5000inches $\pm$ 0.0300	4.5300 4.4700	
10	Cutter Blade	1.3000inches $\pm$ 0.0100	1.3100 1.2900	
11	Cutter Blade	3.2000inches $\pm$ 0.0100	3.2100 3.1900	
12	Cutter Blade	0.4900inches $\pm$ 0.0300	0.5200 0.4600	
13	Cutter Blade	0.7500inches $\pm$ 0.0100	0.7600 0.7400	Radius
14	Cutter Blade	51.6000degrees $\pm$ 0.5000	52.1000 51.1000	
15	Cutter Blade	30.0000degrees $\pm$ 0.5000	30.5000 29.5000	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042173



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO042173
PO Date: 1/7/19
Due Date: 1/21/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments: ** big rush, would it be possible to get these back in 2 weeks? **

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		D5557-1	Cutter Blade : Various STC's PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed	-	1/21/19	4 pcs	0 pcs	4 pcs	\$81.00/pcs	\$324.00

4x

JAN 14 2019

Grand Total: \$324.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
333131	1	133778

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
042173		A2	2019/1/7	FEDEX

QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
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✓ 4 D5557-1
CUTTER BLADES
1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 4

POIDS EXPÉDIÉ / Weight Shipped : 1,20

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 4

POIDS EXPÉDIÉ / Weight Shipped : 1,20

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2019/01/11

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
333131	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
042173 ✓	N/A	A2		
<u>SPÉCIFICATIONS DU PROCÉDÉ</u> processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	4 (907)	61 - 62 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
4 ✓	1.2	D5557-1 ✓ CUTTER BLADES 1 BOITE DE CARTON		

COMMENTAIRES / comments

AGE HARDEN 1800F, 1 HR
DOUBLE TEMPER 400F, 2 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

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APPROUVÉ par / Approved by

Isabel Otero

Isabel Otero
QA Technician



DATE: 2010 01 11

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

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Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
333131	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
042173 ✓	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	4 (907)	61 - 62 HRC

DAS
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9-89

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
4	1,2	D5557-1 CUTTER BLADES 1 BOITE DE CARTON

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2019-01-11

Pierre Piché
Chief Inspector



APPROUVÉ